

Date: Tuesday, 12/5/2006 8:18:22 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW MOD KIT
 Job Number : 29802
 Estimate Number : 11182
 P.O. Number : *NIA*
 This Issue : 12/5/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : SMALL/MED FAB
 Previous Run : 27893
 Part Number : D350615041
 Drawing Number : D350-615
 Project Number : N/A
 Drawing Revision : B
 Material : *NIA*
 Due Date : 1/15/2007 Qty: 100 Um: Each
 Written By :
 Checked & Approved By : *KS 06 12 05*
 Comment : Est Rev:K Removed Manufacturing 05-12-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



100

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

KS 06 12 11

2.0 29802A "T" HANDLE ASSEMBLY



Comment: Sub-Component "T" HANDLE ASSEMBLY

D2282-041 B *29802A*

3.0 29802B SADDLE ASSEMBLY



Comment: Sub-Component SADDLE ASSEMBLY

D2282-043 B *29802B*

4.0 D30153 Lock Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 300.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3015-3 5/16 Locknut

*B28706**X206**B 30169 X 100 94**ml*

5.0 D30155 SS Nylock Nut 7/16



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-5 7/16 Locknut

*B29814**07/01/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:18:22 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 29802

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

51618015C

SS Bolt 5/16-18 1.5" L



Comment: Qty.: 3.0000 Each(s)/Unit Total: 300.0000 Each(s)

*

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

M 103165 ~~x193~~ 193

M 102940 ~~100x~~

M 17167 7X

ml

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 12.0000 Each(s)/Unit Total: 1200.0000 Each(s)

*

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer

M 102940 ~~x100~~

M 19624 ~~x17~~

~~M 103117 x1000~~

M 103133 ~~x1000~~ x1000

M 103165 ~~x48~~

M 116988 ~~x31x~~

8.0

71614050C

SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long

M 101653 ~~x13x~~

M 102945 ~~x87x~~

pas dans l'inventaire

9.0

716WC

SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer

1 D2282-041(Ref) "T" Handdle Assembly

1 D2282-043 (Ref) Saddle Assembly

B29802A

B29802B

M 15747 ~~x6~~

M 1947 ~~x40x~~

M 102940 ~~100x~~

M 102977 ~~x54~~

ml

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

ml
07/01/11

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/01/11 ~~100~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:18:23 AM
User: -Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 29802

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location: _____

PPP Rev: E

67/01/17 (23)
EP 07/01/17 100

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/01/17

Job Completion



CL07/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED BW	DRAWING NO. D350-615	REV. B SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

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WITHOUT NOTICE
WORK ORDER
NO. **29802**

DART

DESIGN	KE	DRAWN BY	KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED	WJ	APPROVED	WJ	DRAWING NO. D350-615	SHEET 2 OF 2
DATE	97.10.21	TITLE	GROUND HANDLING WHEEL MOD.	SCALE	NTS

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

EXISTING PUMP
BODY

D2282-043 SADDLE
ASSEMBLY

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)

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NO. 29802

Date: Tuesday, 12/5/2006 8:18:27 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : "T" HANDLE ASSEMBLY
 Job Number : 29802A
 Estimate Number : 11179
 P.O. Number : Part Number : D2282041
 This Issue : 12/5/2006 S.O. No. : Drawing Number : D2282 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : E
 Previous Run : 27893A Material :
 Due Date : 1/15/2007 Qty: 100 Um: Each
 Written By :
 Checked & Approved By : *06 12 05*
 Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D22823 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

(100)

Pick:

Qty Part Number Description Batch
 1 D2282-3 Handle tube *327898*

Cpl 06-12-18

2.0 D22825 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

(100)

Pick:

Qty Part Number Description Batch
 1 D2282-5 Handle tube *327899*

Cpl 06-12-18

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

(100)

1-Weld as per D2282-041 'T' Handle Assembly
 Grind chamfers and ensure full penetration.

A/R ER316L SS Filling Rod *M102756*
 Dwg Rev: *E*

Cpl 06-12-18

4.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

Nov 12/19 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:18:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 29802A

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

JAN 07:01:06

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/01/08

100

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

ml 07/01/08

100

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 0706.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

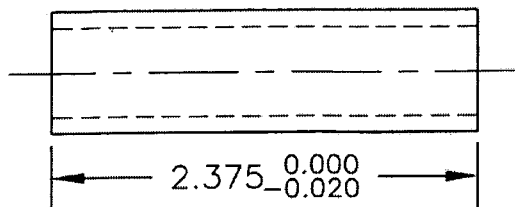
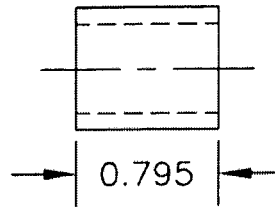
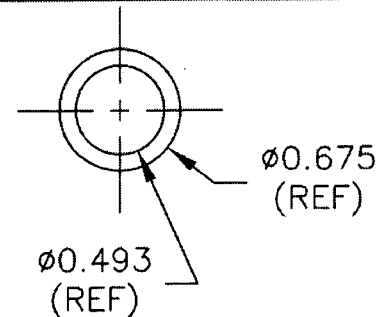
NOTE: Date & initial all entries

DART

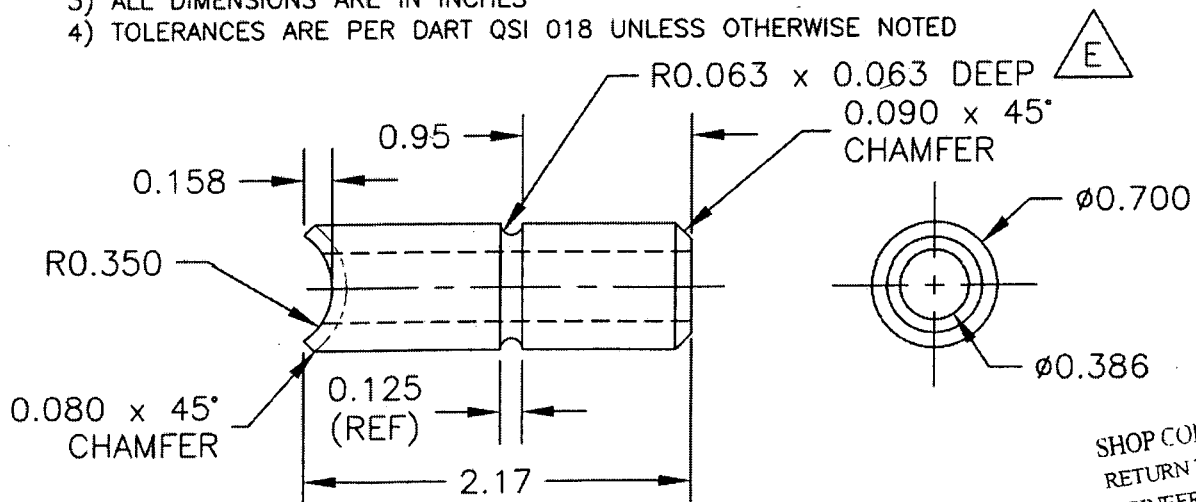
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

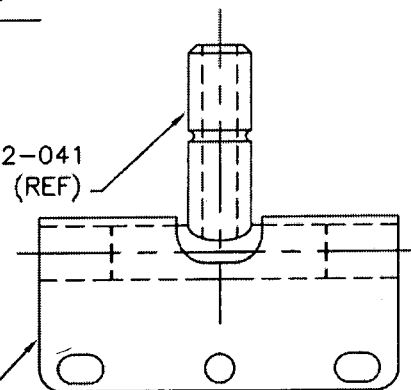
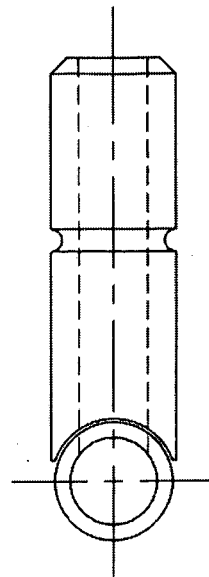
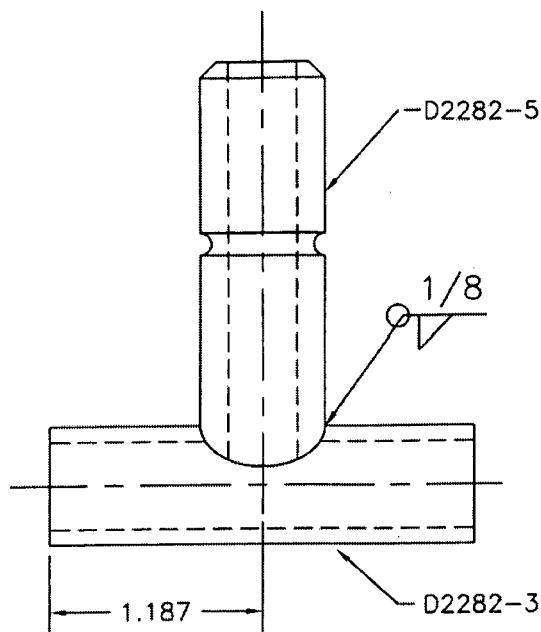
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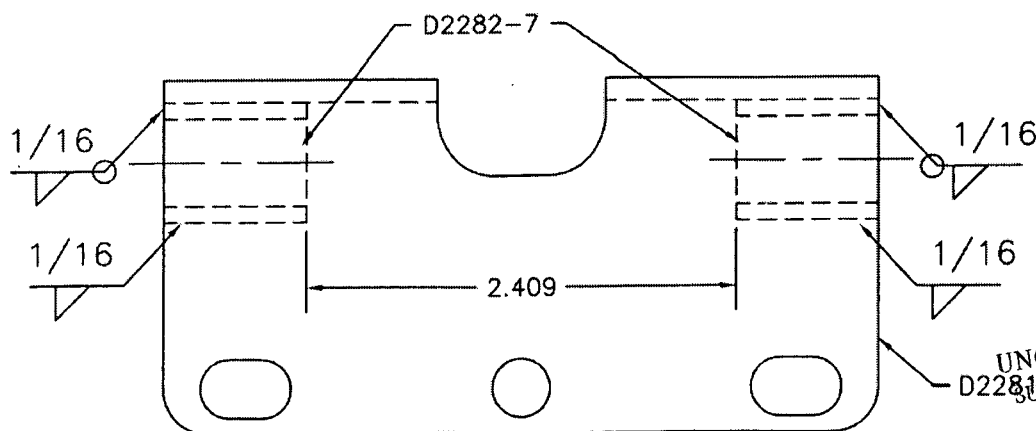


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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES.	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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